Work Order ID 71500

Tuesday, July 05, 2011 9:01:16 AM

Item ID: D206-667-203TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail
Start Date: 7/5/2011 **Start Qty:** 1.00
Required Date: 7/25/2011 **Req'd Qty:** 1.00
Reference:

Accept

Setup Start

Stop

Cust Item ID:
Customer:

Run Start

Stop

Approvals: **Process Plan:** CL **Date:** 11/07/05 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D206-667-243	Rev C U/R OK 11.07.06								
100	MORI SEIKI CNC LATHE LARGE	0.00				1	0		
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs ID 18554 on both ends as per Folio FA089								
	2-Turn first side as per Folio FA089								
	3-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
110	QC1- Inspect dimensions to dimension sheet	0.00							
QC	**Memo**	0.00							
Quality Control									

SCRAP

MM.L 11/07/25

Dart Aerospace Ltd

W/O: 71500

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-203TRN PAR #: _____ Fault Category: Machining X-Tube NCR: (Yes) No DQA: _____ Date: 11.09.08

11-8980 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 11/09/08

NCR: 68.11

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11.08.11	100	Ø4.933" O.D. IS Ø0.417" PORT TAPER IN WRONG POSITION R.C. operator offset was WRM LOA 2	11.08.31 per QST	SCRAP, HIGH STRESS AREA OF TUBE AFFECTED. DEVIATION IS LARGER THAN ALLOWABLE MAX REPAIR OF 0.015" @ 11.08.11	SAD 11-09-02	11/09/02	11.08.31 (KB Delegate)	11/09/02

NOTE: Date & initial all entries

Work Order ID 71500

Tuesday, July 05, 2011 9:01:16 AM

Item ID: D206-667-203TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail
Start Date: 7/5/2011 **Start Qty:** 1.00
Required Date: 7/25/2011 **Req'd Qty:** 1.00
Reference:

Cust Item ID:
Customer:

Accept **Setup Start** **Stop** **Run Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA089 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatediy with file card. *Do not use sandpaper coarser than 320 grit. 3-Remove sand and plugs 4-Scrib part# and batch #								
130	QC1- Inspect dimensions to dimension sheet	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 71500

Tuesday, July 05, 2011 9:01:16 AM

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Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Crosstubes Chemical Conversion	0.00							
HandFXtube	**Memo**	0.00							
Hand Finishing Crosstubes									
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 71500

Tuesday, July 05, 2011 9:01:16 AM

Item ID: D206-667-203TRN
Revision ID: U/R
Item Name: Crosstube Turning Detail

Start Date: 7/5/2011 **Start Qty:** 1.00
Required Date: 7/25/2011 **Req'd Qty:** 1.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging	Identify and Stock in kanban rack☐Location:_____								
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 05, 2011 9:01:13 AM

Work Order ID: 71500

Parent Item: D206-667-203TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 7/5/2011 **Required Date:** 7/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified by: DD
IPP Rev C 09.01.06 ECN 08-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115		Manufactured	No			100	Each	25.0000	1	1			
Crosstube Material													

Location	Loc Qty	Loc Code
LG	25	
34685	5	
38336	20	

1 mmc 11/07/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71500
Description: Crosstube Assembly	Part Number:	D206-667-243
Inspection Dwg: D206-667-243 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

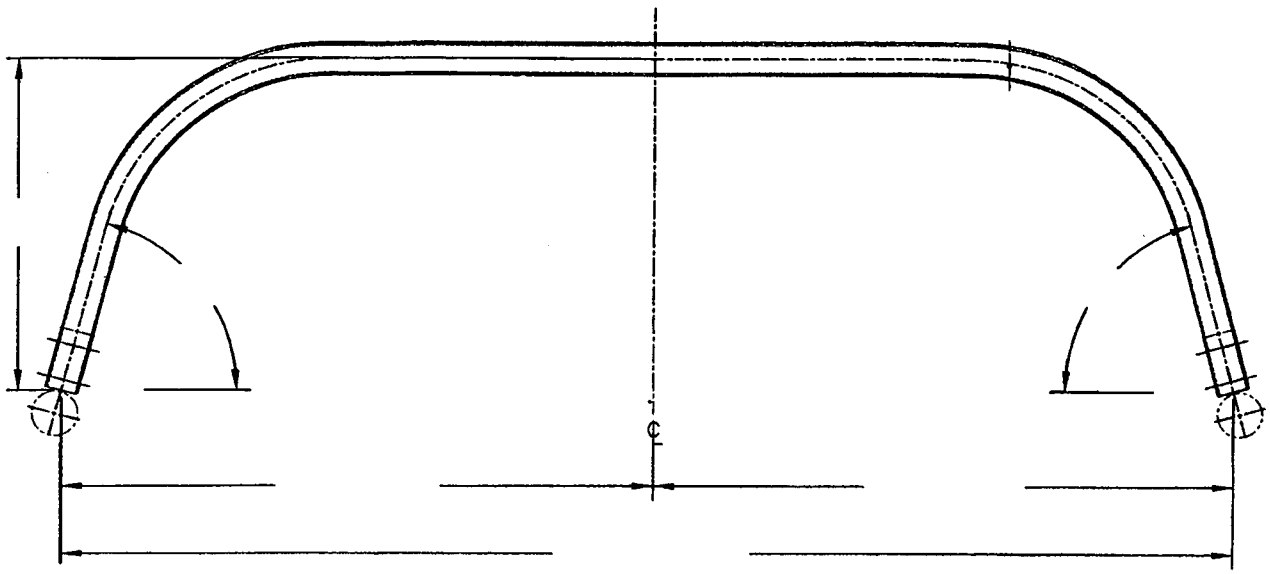
	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000					
	2.018	+0.005/-0.000					
	2.079	+0.005/-0.000					
	2.145	+0.005/-0.000					
	2.209	+0.005/-0.000					
	2.287	+0.005/-0.000					
	2.363	+0.005/-0.000					
	2.433	+0.005/-0.000					
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500 x 30°	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010					
	4.438	+/-0.030					
	104.91	+/-0.020	104.91	✓			
SIDE B	2.490	+0.005/-0.000					
	2.018	+0.005/-0.000					
	2.079	+0.005/-0.000					
	2.145	+0.005/-0.000					
	2.209	+0.005/-0.000					
	2.287	+0.005/-0.000					
	2.363	+0.005/-0.000					
	2.433	+0.005/-0.000					
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500 x 30°	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010					
	4.438	+/-0.030					

Measured by:	MM.V	Audited by:		Preliminary Approval:	N/A
Date:	11/07/25	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	
B	10.08.25	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	71500
Description: Crosstube High Aft (206L)	Part Number:	D206-667-203
Inspection Dwg: D206-667-243 **Rev:** C		Page 1 of 1

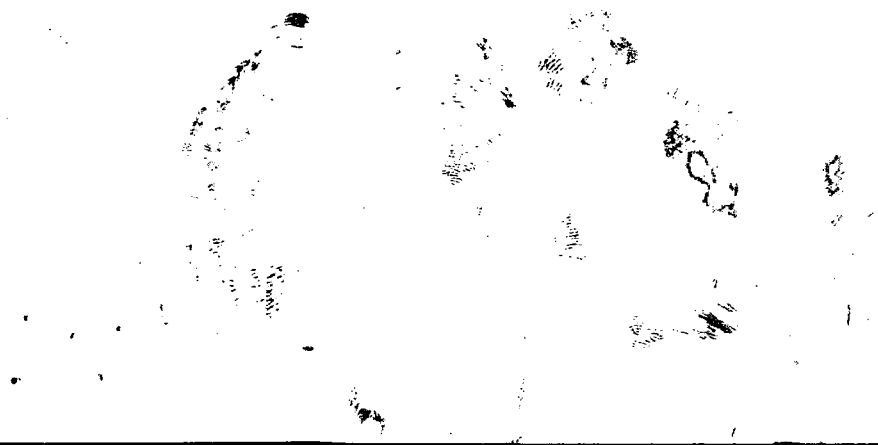
Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.17	Dwg Rev updated	KJ	
C	09.12.14	Dimensions update per Dwg Rev C	KJ	



CHAPTER 5 – INSPECTION REQUIREMENTS (05-00-00)

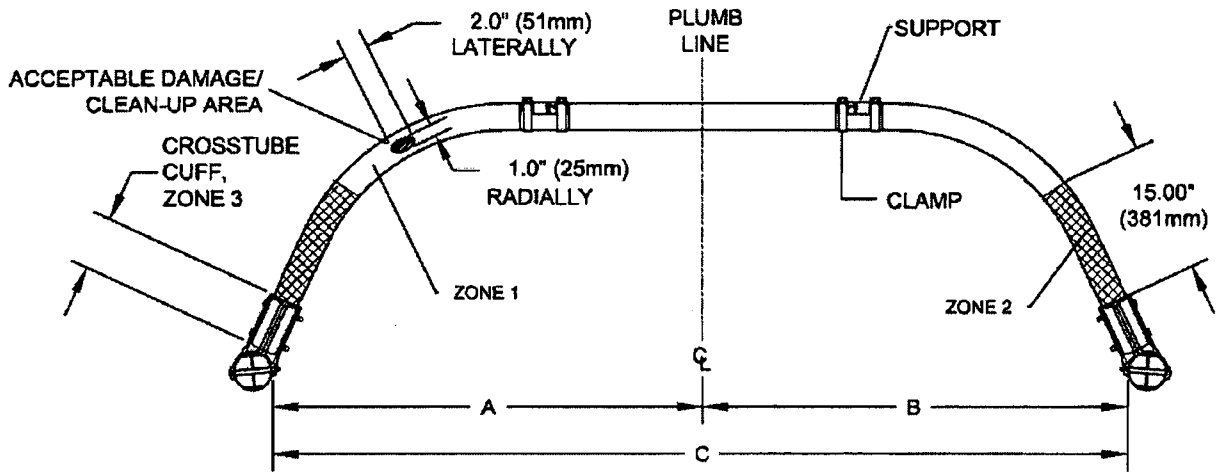
5.1 DAILY INSPECTION

5.1.1 Inspect the landing gear assembly for

a) Mechanical damage (scratches, nicks) and corrosion damage on crosstube
b) Elongation of any of the saddle holes
c) Cracked saddles or supports
d) Break in sealant around the saddles or supports
e) Corrosion damage in the vicinity of the saddles or supports
f) Looseness in the saddle joint
g) Moving or slipping of the supports

If damage or slipping found, perform the 300 hour inspection and repair.

5.2 DAMAGE LIMITS



Maximum Nick, Scratch, or Corrosion Damage Depth Limit			
Damage Zone	**3**	**2**	**1**
D206-667-101 High Fwd Crosstube	0.030" (0.76mm)	0.008" (0.20mm)	0.015" (0.38mm)
D206-667-103 High Fwd Crosstube D206-667-107 Mid Fwd Crosstube	0.030" (0.76mm)	0.012" (0.30mm)	0.015" (0.38mm)
D206-667-201 High Aft Crosstube D206-667-203 High Aft Crosstube D206-667-207 Mid Aft Crosstube	0.030" (0.76mm)	0.015" (0.38mm)	0.015" (0.38mm)

CR1110705
010.71500

Figure 5-1: *Acceptable Crosstube Damage Limits*
D206-667-101/-103/-107/-201/-203/-207 Crosstubes

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Item	Qty -243	Part Number	Description
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6004-115
 FINISHED LENGTH = 104.91±0.020
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: 21.9 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11500
11-07-25

UNDER REVIEW
11.06.17

RELEASED
08/11/17

REV.	DESCRIPTION	BY	DATE
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D6-2 & A5-2); REMOVED REF.'& ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17

DESIGN	QP
DRAWN	RF
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.11.06

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D206-667-243 REV. C
SHEET 1 OF 4
TITLE CROSSTUBE ASS'Y (206L HIGH AFT) SCALE NTS

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Dart Aerospace Ltd

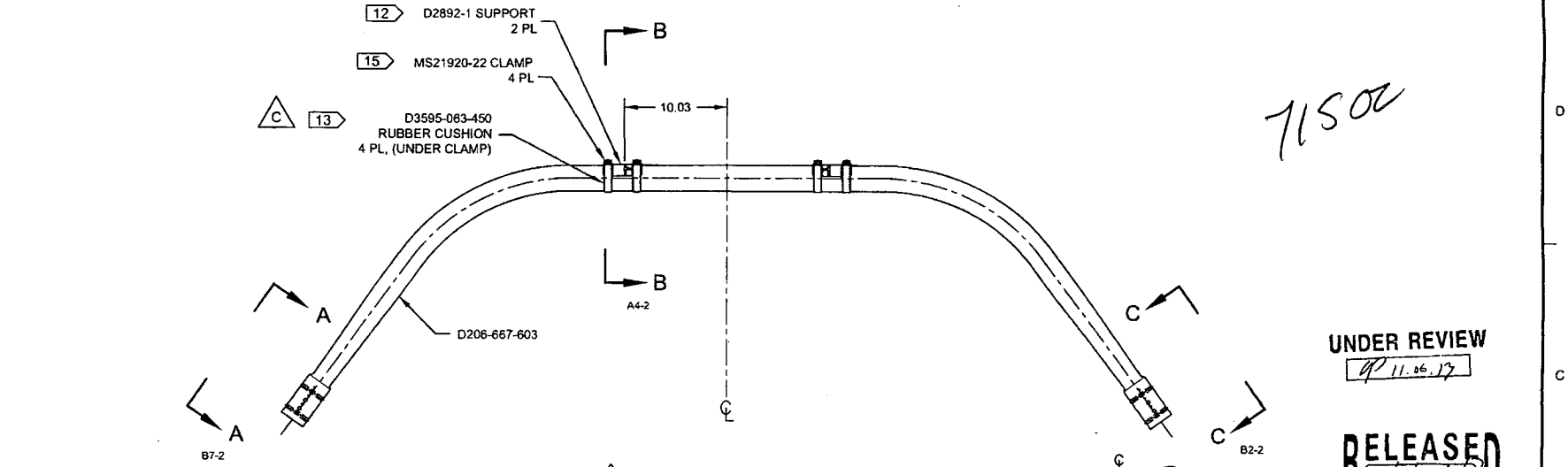
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

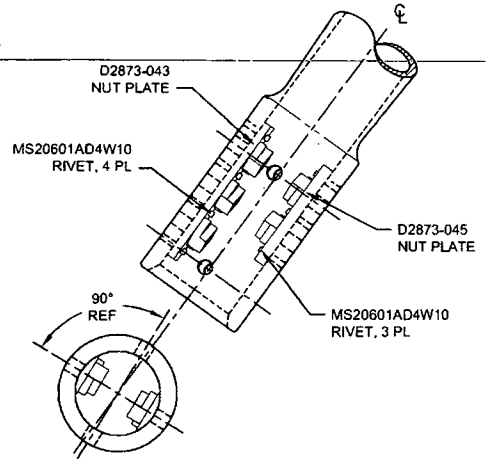
NOTE: Date & initial all entries



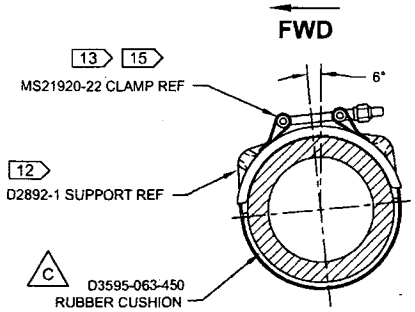
7150

UNDER REVIEW
11.06.17

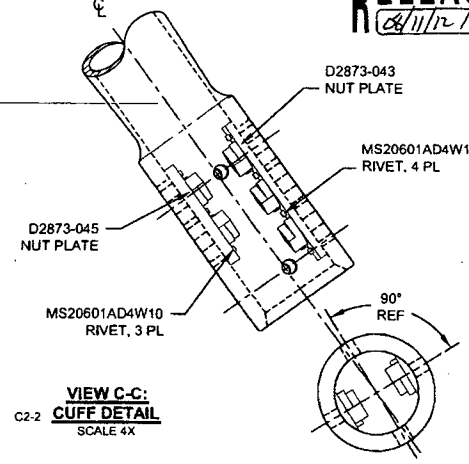
RELEASED
08/11/17



VIEW A-A: CUFF DETAIL
C7-2 SCALE 4X



D5-2 SECTION B-B
SCALE 5X



VIEW C-C: CUFF DETAIL
C2-2 SCALE 4X

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-243 REV. C SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) SCALE NTS
DE APPR.		
DATE	08.11.06	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

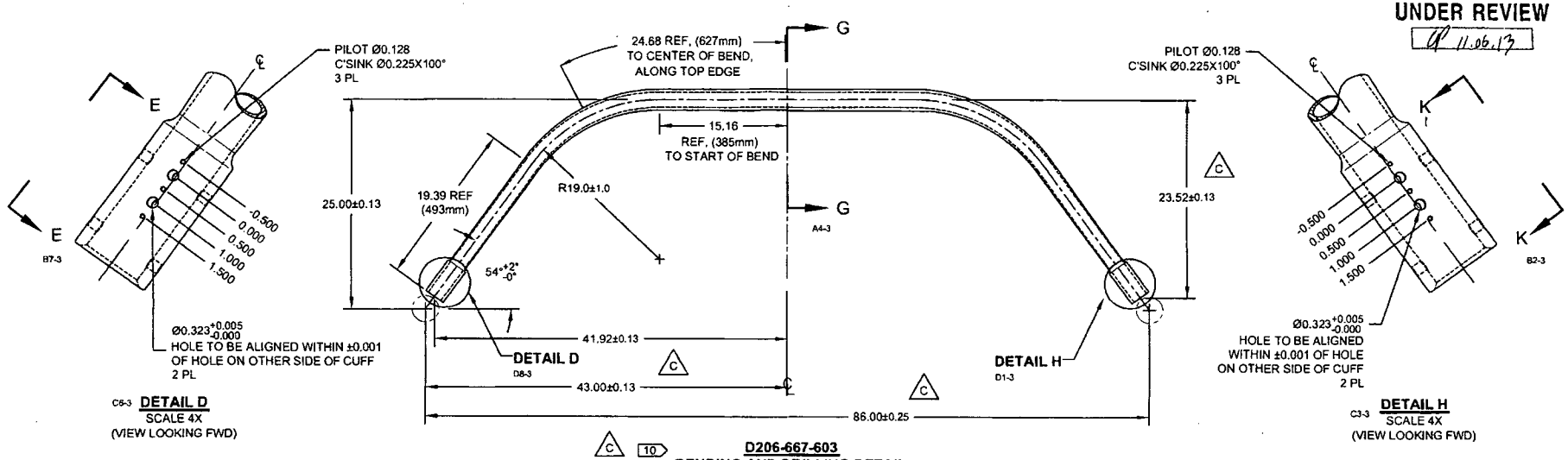
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

7500

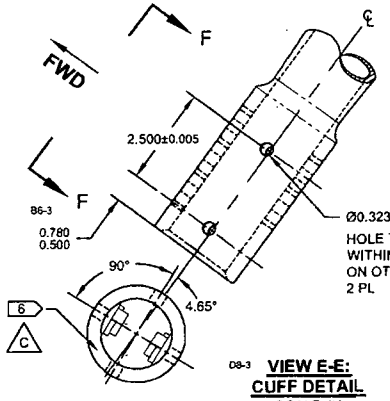
UNDER REVIEW
11.06.13



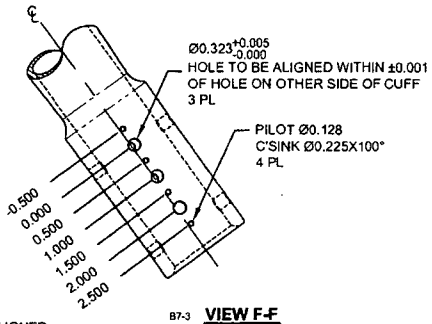
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SCALE 4X
(VIEW LOOKING FWD)

C3-3 **DETAIL H**
SCALE 4X
(VIEW LOOKING FWD)

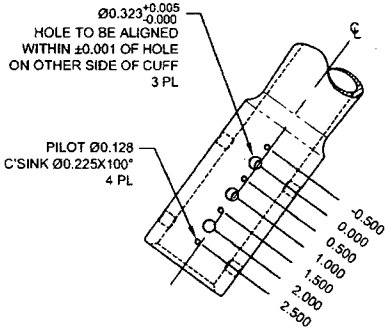
D206-667-603
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)



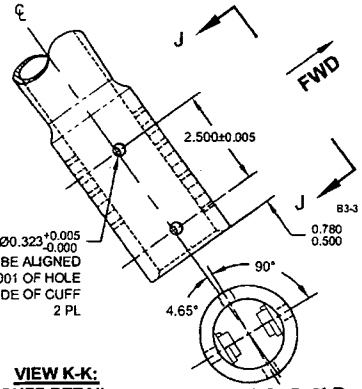
D8-3 **VIEW E-E:**
CUFF DETAIL
SCALE 4X



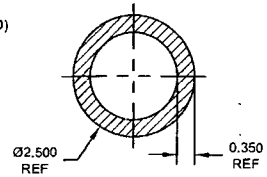
B7-3 **VIEW F-F**
(VIEW LOOKING AFT, ROTATED)



B2-3 **VIEW J-J**
(VIEW LOOKING AFT, ROTATED)



D1-3 **VIEW K-K:**
CUFF DETAIL
SCALE 4X



D4-3 **SECTION G-G**
SCALE 5X

RELEASED
08/11/12

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-243 REV. C SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) SCALE NTS
DE APPR.		
DATE	08.11.06	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

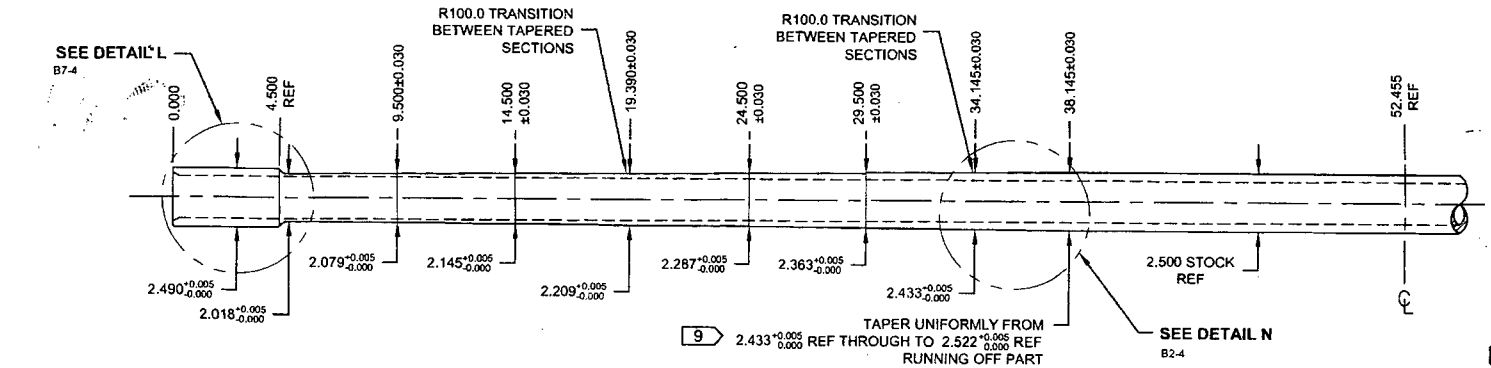
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

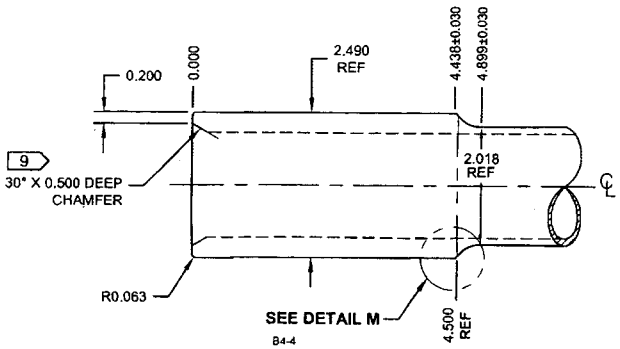
NOTE: Date & initial all entries

71502

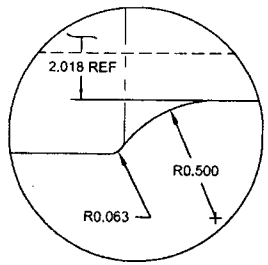


C TURNING DETAIL

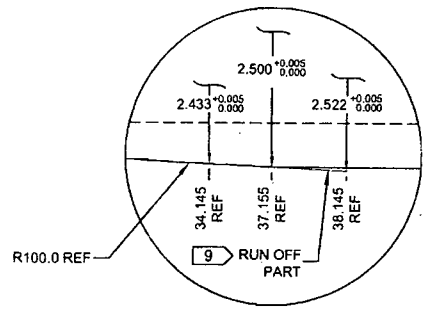
UNDER REVIEW
AP 11.06.13



C7-4 **DETAIL L: CROSSTUBE CUFF**
NOT TO SCALE



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED
08/11/06

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-243 REV. C SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) SCALE NTS
DE APPR.		
DATE 08.11.06		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries